*SPLit [illegible]

Work Order ID 91747 – 2
Wednesday, October 17, 2012 1:56:29 PM

91747

Item ID: D3121-25
Revision ID:
Item Name: Cap
Start Date: 10/17/2012 **Start Qty:** 100.00 *100*
Required Date: 10/19/2012 **Req'd Qty:** 100.00 *100*

Accept ~~100.0~~ 90.0

N900040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** mf **Date:** 12-10-17 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3121	**Revision Nbr** Rev E								
100 *100* Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE SMALL **Memo** 1-Turn D3121-25 Cap as per Folio FA3872-Deburr	0.00 0.00	SS 12/10/18			90	Ø		
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	SS 12/10/18			90	Ø		
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	DAS 25 9-89 12-10-19			90			

Work Order ID 91747

Wednesday, October 17, 2012 1:56:29 PM

91747

Item ID: D3121-25 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Cap

Start Date: 10/17/2012 **Start Qty:** 100.00 *100* **Cust Item ID:**

Required Date: 10/19/2012 **Req'd Qty:** 100.00 *100* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: ST 235	0.00				90			12/10/19 JB
	Memo	0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					12/10/22		
	Memo	0.00							

pl 12-10-19

Picklist Print

Wednesday, October 17, 2012 1:56:29 PM

Work Order ID: 91747
Parent Item: D3121-25
Parent Item Name: Cap

Start Date: 10/17/2012 **Required Date:** 10/19/2012
Start Qty: 100.00 **Required Qty:** 100.00

Comments: IPP Rev:A New Issue 06-05-10 JLM
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 DELRIN ROUND BAR 1.25"		Purchased	No			100	f	21.4250	0.052	5.4736842 ~~4.5~~ 3.875'		12/10/18	

Location	Loc Qty	Loc Code	
MAT055	21.425		
119133	0.92		
121971	0.03		
→ 122582	20.475		~~4.5~~ 3.875'

DART AEROSPACE LTD	Work Order:	91747
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[x] First Article [ ] Prototype

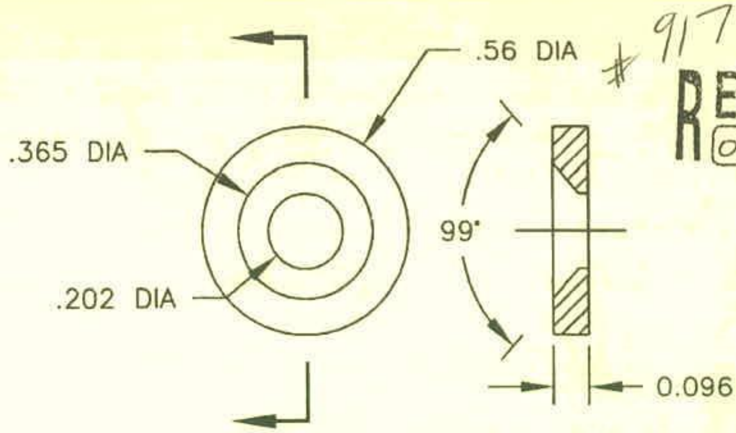
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	.317	✓		SL08	Vern
Ø1.000	+/-0.010	1.000	✓		SL02	Mic
Ø0.838	+/-0.002	.837	✓		SL08	Vern
R0.063	+/-0.010	.063	✓		↓	
R0.010	+/-0.010	.015	✓		↓	
0.230	+/-0.001	.229	✓		↓	
Ø0.865	+/-0.001	.866	✓		↓	

Measured by:	[signature]	Audited by:	DAS 25	Prototype Approval:	N/A
Date:	12/10/18	Date:	12-10-19	Date:	N/A

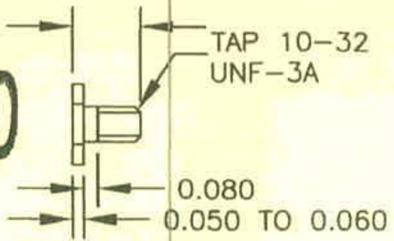
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD [signature]	[signature]

DART

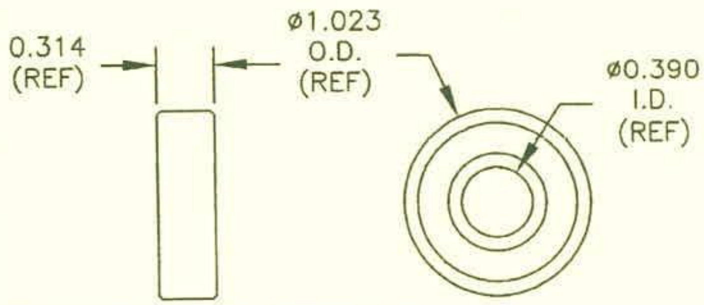
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



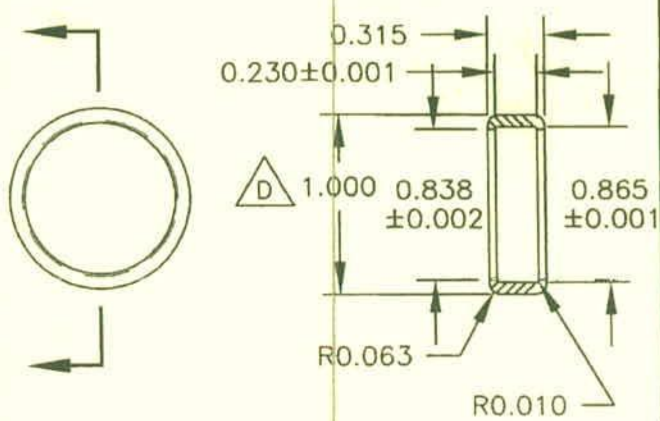
D3121-17 WASHER (SCALE 2:1)
1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED
(REF DART SPEC. M303R)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



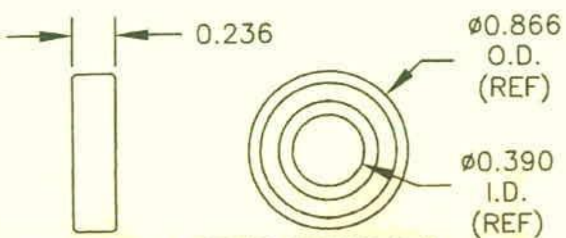
D3121-21 BOLT (SCALE 1:1)
1) MATERIAL: AISI 303 SS HEX, ANNEALED
(REF DART SPEC. M303H0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



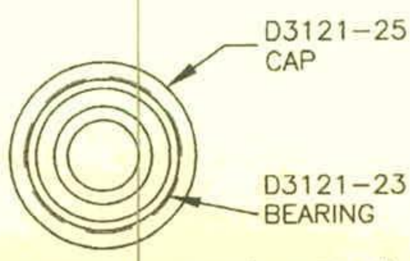
D3121-19 BEARING (SCALE 1:1)
1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
2) ALL DIMENSIONS ARE IN INCHES



D3121-25 CAP (SCALE 1:1)
1) MATERIAL: DELRIN ROD, ø1.25
(REF DART SPEC. M-DELRIN-R1.250)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)
1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
2) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)